Work Orde June-24-13 2:1		3664		*103	3664*	·						Page 1
Item ID: Revision ID:	D2933-1		A	ccept	*N900	040	100)*	Setup	Start	*N.	S1*
Item Name:	206 Saddle Le	:ft								Stop	*N:	S2*
Start Date:	6/24/13	Start Qty: 6.00	*6*		Cust Item II	D:						
Required Date:	7/12/13	Req'd Qty: 6.00	*6*		Customer:							
Reference:									_	G		
Approvals:	Process Pla	in: MLJ	Date: 13-06-25	Tooling:	Da	ite:			Run	Start	*N!	R1*
			•	SPC (Y/N):	Da	ıte:				Stop	*NI	R2*
Sequence ID/ Work Center II	 D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			-							
D2933	Rev	C										•
100				0.00				12				
100<		HAAS CNC VERTICA	L MACHINING #1					6				X13-8-18
HAAS I	•	Memo		0.00								
HAAS CNC vertica	! machine #1	number are inspect as p	rt number and batch number. programmed correctly.2-Macer dwg D2933 & attached Did t visually inspect as per :	chine Step No 1 of Fol	io and visually							
110			•	0.00								
110		CONVENTIONAL MII	LING MACHINE		11.	3-08-21		le	Æ	1		
Mill Conv		Memo		0.00	<i>M</i> 41.	7.09-01				`		
Conventional Millin	ng Machine	Machine K	eyway and inspect per attache	d dimension sheet	·							
120 :		QC1- Inspect dimension	ns to dimension sheet	0.00								
120								<u>le</u>		0		SL13-8-18
QC		Memo		0.00								·= ·

Quality Control

DQA:			_ Date:										*
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UF		Work Order	update only	AEROSPACE
						DISPOSITION					,	IT/PROCESS	
Work Orde	≥r: -	· · · · · · · · · · · · · · · · · · ·			—	n anti-	۱ ا		CLUM ALINA	6	\neg	\ 4 /-4-" 1-4	
Part N	ماد					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	\dashv ,	Water Jet rod. Eng. Coor.	Engineering Quality
raiti	٠٠	<u> </u>				Use-as-is			noforming	Finishing		ore/Packaging	Other
NCR N	No.					Suspected Unapproved		inen	Large Fab	Composite	- 1100/31	Supplier	
*****	-						1						
Root		· · · · · · · · · · · · · · · · · · ·			Desc	ription of work order update		Initial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Design				_	_								
Doc/Data													
Equip/Tooling					ļ		•						
Handling/Pre													
Material													
Operator			!				l						
Offset/Setup			ŀ										
Process													
Supplier													
Training													
Transport													
Unapproved													
<u> </u>							FAI	ULT CA	regory				
Landi	ng G	iear				General		_				_	<u></u>
:		Bending			L	Bend	L	Folio/F	Program	. [Outside Di	mensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Und	er tolerance	Set-up
		Cracks				Broken/Damage/Defect	Ĺ	Hardwa	ire		Part Incom	ect	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/	Missing	Weld
		Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear	Part Move	ď	Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center	[Positioned	Wrong	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Los	s/Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misread	t	_			
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of t	Sequence				

Work Order ID 103664 *103664* Page 2 June-24-13 2:11:30 PM Item ID: D2933-1 Accept *N900040100* Setup Start Revision ID: Stop Item Name: 206 Saddle Left Start Date: 6/24/13 Start Oty: 6.00 Cust Item ID:

Required Date: 7/12/13 Req'd Qty: 6.00 **Customer:**

Reference:

OC

Run Date: Tooling: Date: Approvals: Stop Date:_____ SPC (Y/N): Date:

Tool ID Tool # Plan Reject Reject Sequence ID/ Operation Set Up/ Accept Insp. Work Center ID Code Qty **Qty** Number Stamp Description **Run Hours** 0.00 130 OC8- Inspect parts - second check 13/08/22 *120*

Chemical Conversion Coat per OS1005 4.1 140

Memo

0.00

140 HandFinish

Quality Control

Memo

Hand Finishing

0.00

White Gloss(Ref:4.3.5.1) per QSi005 4.3-Alum

0.00

150 Powdercoat .

150

Powder Coating

Memo START TIME:

OVEN TEMPERATURE:

_FINISH TIME:

9-15

6xxmf13/08/2

6 78,13.8.22

mablas

DQA:		_ Date:										
					WORK ORDER NON	-C(ONFO	RMANCE / UPDATE		rec.		AEROSPACE
QA Closed:		Date:							Wo	ork Order up	odate only	
Work Orde	er:				DISPOSITION			AGAINST	r dei	PARTMENT	/PROCESS	
					Rework]		Skid-tube Crosstube	<u>,</u>		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining Small Fat	\vdash	Pro	d. Eng. Coor.	Quality
				_ !	Use-as-is	1	Therr	moforming Finishing			re/Packaging	Other
NCR N	No				Suspected Unapproved			Large Fab Composite	· 🗌		Supplier	
Root				Desci	ription of work order update		nitial	Action		Sign &		T
Cause	Date	Step	Qty	_	or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling						1						
Handling/Pre												
Material							5					
Operator				•		1	20					
Offset/Setup												
Process	_					l						
Supplier												
Training	<u></u>											
Traॄnsport												
Unapproved		<u> </u>				<u> </u>		<u> </u>				
						FA	ULT CA	TEGORY			·	
Landır	ng Gear				General	_	۱					¬
ł	Bending	- .			Bend BOM /Bassta	⊨		Program	-	Outside Dim	⊢	Pressure/Forced
	Centre N	ot Concer	ntric	-	BOM/Route	⊢	Grain		\vdash	Over/Under	<u> </u>	Set-up
}	Cracks	l - /0: l	hata	-	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorred	⊢	Temperature/Cure
}	Crimp/Ki	пк/кірріе	/wave	-	Burrs	<u> </u>	1	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	ssing	Weld
}	Cuffs			\vdash	Contamination	├	4	tions Incomplete/Unclear	\vdash	Part Moved	L	Wrong Stock Pulled
ŀ	Crushing			\vdash	Countersink Cut Too Short	⊢		gned/off center		Positioned W		Joshan
	Heat Trea		Tuba	\vdash		\vdash	Mislabe		Ш	Power Loss/:	ourge	Other
	Inspectio Marks/Cl	· .	rupe	\vdash	Drawing Drill Holes	\vdash	Misrea		-	·		
ļ	Turning S				Finish	-	Off-set	Calibration	-			
	Wave/Tw			\vdash	Fit/Function	\vdash	ł	Lalibration Sequence	-			

Work Order I June-24-13 2:11:30			*103	3664*				P.	age 3
Revision 1D:	33-1 Saddle Left /13 Start Qty: 6.00	*6*	Accept	*N900 Cust Item I		೧* s	etup Sta Sto	14.7 1	
Required Date: 7/12 Reference:	/13 Req'd Qty: 6.00	*6*		Customer:		Т	tun Sta	ert 1.5 1.5 4	:
	cess Plan:	Date:		·	nte:	- -	Sto	"NK I	*
Sequence ID/ Work Center ID 160 *160* QC Quality Control	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code		Reject Qty	Reject Insp Number Stari	np S h
170 *170* Packaging Packaging	ldentify as per dwg & St Memo	ock Location: 574	3 7 0.00 0.00			_6x		M.D. 13-	<u>08</u> -27
180 *1 20* QC Quality Control	QC21- Final Inspection Memo	- Work Order Release	0.00				13,	18/29 d	9
							A) 12	18.38	

DQA:			Date:											AD A D	Γ
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / U		\Mc	ork Order up	ndate only	AEROSPAC	E
QA Closed.			Date.		_						***	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT,	/PROCESS		
						Rework]		Skid-tube	Crosstube			Water Jet	Engineering	
Part N	10.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	Quality	
						Use-as-is			noforming	Finishing			re/Packaging	Other	
NCR N	No			<u>.</u>	_	Suspected Unapproved]		Large Fab	Composite			Supplier		
Root					Desci	ription of work order update		nitial	Ac	tion		Sign &			_
Cause	ī	Date	Step	Qty		or non-conformance	Ch	ief Eng	_ Desc	ription		Date	Verification	QC Inspector	
Design															
Doc/Data											[
Equip/Tooling															
Handling/Pre					1						Ì				
Material 📑											-				
Operator			!								l				
Offset/Setup				!											
Process	_	ł					1				ŀ				
Supplier				!]				ļ				
Training											ĺ				
Transport		Ì													
Unapproved	i			[<u> </u>	<u> </u>	HT CAT	TEGORY		l				
 Landir	ng Gen					General	FAI	OLI CA:	IEGORT						
		nding				Bend		 Folio/P	Program	1		Outside Dim	ensions [Pressure/Forced	
ŀ		-	t Concer	ntric		BOM/Route		Grain	· og·um	i	-	Over/Under	}	Set-up	
Ì	_	icks	2 25.1001	12110	-	Broken/Damage/Defect	\vdash	Hardwa	are			Part Incorred	_	Temperature/Cure	
Ì	—		k/Ripple	/Wave		Burrs	H	1	c ion Incomplete/U	Inqualified	-	Part Lost/Mi	H-	Weld	
ŀ	Cu	-	.,,	,		Contamination		1 '	tions Incomplete/	· · · · · · · · · · · · · · · · · · ·	_	Part Moved	· ·	Wrong Stock Pulled	
Ì		ıshing				Countersink	\vdash	4	ned/off center	,	-	Positioned W			
	_	at Trea	t			Cut Too Short		Mislabe			-	Power Loss/		Other	
i	_		Strip in	Tube		Drawing		Misread		'		·	- L		_
ľ	_	rks/Ch				Drill Holes		Off-set			-				
ļ	Tu	rning Se	equence			Finish		Out of 0	Calibration		-		•	-	
	W:	ave/Twi	ist in Tub	e		Fit/Function .	\Box	Out of S	Sequence		-				_

Picklist Print

June-24-13 2:11:29 PM

Work Order ID:

103664

Parent Item:

D2933-1

Parent Item Name:

206 Saddle Left

Start Date: 6/24/13

Required Date: 7/12/13

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch -	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 Saddle Billet	,,,,,,	Manufactured	No			100	Each	44.0000	16	6	SL 13	-08-1	6
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT042		44							
				972	39	27							
				984	56	17							
				103	637				_6	,			

DQA:		Date:										*	` ΔART	•
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPI		Vork Order i	update only		AEROSPACE	
				-	DISPOSITION		Γ							•
Work Orde	er:			!	DISPOSITION				AGAINST	EPARTMEN	I/PROCESS			
					Rework			Skid-tube	Crosstube		Water Jet		Engineering	
Part N	lo				Scrap			Machining	Small Fab	Pr	od. Eng. Coor.		Quality	
			•		Use-as-is		Thern	noforming	Finishing	Rec/St	ore/Packaging		Other	
NCR N	lo				Suspected Unapproved			Large Fab	Composite		Supplier			
Root				Desc	ription of work order update	1	Initial	Actio	on	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descrip	otion	Date	Verificatio	n	QC Inspector	_
Design					· · -									
Doc/Data												1		
Equip/Tooling										ŀ]			
Handling/Pre														
Material														
Operator	_													
Offset/Setup														
Process														
Supplier	_											ļ		
Training	_													
Transport	_													
Unapproved			<u>l</u>	<u> </u>		<u></u>								-
						FA	ULI CA	TEGORY						-
Landir	ng Gear	_			General	_]	\	Г	Outside Di			ressure/Forced	
}	Bendir	_		-	Bend BOM/Route	-	Grain	Program	⊢	—		_		
}		Not Conce	entric	-	Broken/Damage/Defect	┝	4		-	Part Incorr	er tolerance	_	et-up emperature/Cure	
}	Cracks	Kink/Ripple	- /\#I=	\vdash	-	\vdash	Hardwa	ire ion Incomplete/Ung		Part Incom	-	\vdash	/eid	
}	⊣ ``	кикукирри	e/ wave		Burrs	\vdash	1 '	•	· -			—┪		
}	Cuffs Crushi	20		\vdash	Contamination Countersink	\vdash	4	tions Incomplete/Un gned/off center	icieai -	Part Move Positioned		v	rong Stock Pulled	
ļ	Heat T	_		-	Cut Too Short	\vdash	Mislabe		<u> </u>	Positioned Power Loss			ther	
}		reat tion Strip ir	Tuba		Drawing	\vdash	Misrea		L	rower cos:	y Juige	Щ	<u> </u>	-
}	─	(Chatter	rube	-	Drill Holes	-	Off-set					···		-
}		g Sequence	.		Finish	\vdash	4	Calibration			-			-
		Twist in Tul			Fit/Function	\vdash	4	Sequence						-
	1 /				1 ,									

DART AEROSPACE LTD	Work Order:	103664
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First	Article	Proto	otype		
		·			Record	d Actual Dir	nensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Α	0.100	0.140		-121	121	-121	lai	-
В	0.100	0.140		-121	-181	-121	-121	
C	0.100	0.140		120	-120	1-120	-120	
D	0.210	0.230		-224	-224	2224	224	1
E	1.245	1.255		1250	1,250	1.250	1,250	
F	1.245	1.255		1,250	1.25o	1.250	1.25o	
G	2.495	2.505		2.500	2-500	Q.500	2,500	
<u>H</u> _	0.510	0.515		0512	.5/2	1512	1512	
_	1.572	1.582		1.577	1.517	1,544	1 414	
J	2.495	2.505		2,500	2.500	2.500	2.500	
K	0.257	0.262		-258	258	258	-258	
L	0.312	0.317		-314	-3(4	-314	1-314	
M	0.235	0.240		.738	.238	.238	.238	
N	0.100	0.140		-123	-123	123	_123	
0	0.540	0.560		549	- 54B	1249	-549	
Р	0.490	0.510		- 500	.501	499	भर्द्र	<u> </u>
Q	3.715	3.725		37720	3.720	3.720	3.720	
R	2.470	2.510		2.490	2.490	Q 490	2490	
S	0.240	0.270		253	-251	2251	251	
T	0.100	0.180		-135	135	-BS	135	
U	1.625	1.635	<u>-</u>	1-630	1630	1.630	1.630	
V	1.362	1.372		1.367	1-367	1367	1367	-
W	0.316	0.321		-316	-36	-316	3/6	
X	1.125	1.145		1./38	1./38	1.38	138	
Y	1.565	1.585		1.548	7.578	1,548	1.578	
Z	0.178	0.198		- 188	188	188	_188	
AA	_				100	1.00	-150	
AB						-		
AC_						-	-	
AD						 		
AE								
			Accept/Reject					
	Measured		• ()	15-88-51		Date:		
	Audited		8-18	λÂ ŶÆ		Date:	13 08/	27
Proto	type Appro	oval:		V/A		Date:		N/A
Rev	Date	Change					evised by	Approved
A B	02.12.12	New Issue Re-format; Ac	ded Dim. X-Y,	DT8683. DT	8686. DT869	RF		
		DT8695 A/B				KJ	/RF	1
C D	06.10.03 07.03.21	Removed DT	8683, DT8686 8	DT8690			/JLM	
		DTOCOS ALC	rawing revision	<u>U</u>			/JLM	
E	08.01.16	D18682 W/B L	emoved from di	mension Y		KJ	/EC/DD	1 1X

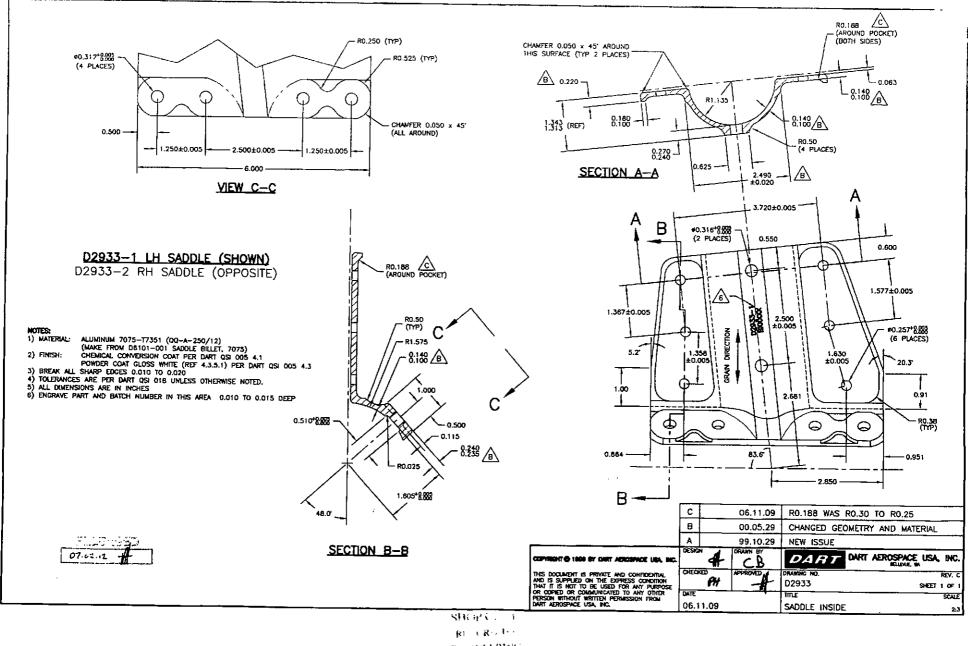
	• *						
		•					
•							
				1			
•						ι,	
						•	
			•				
					,		
					•		
-	- •						

DART AEROSPACE LTD	Work Order:	103664
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

			X First	Article	Proto	type		
					Record	Actual Din	nensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Α	0.100	0.140		121	121			
В	0.100	0.140		1-121	121			
С	0.100	0.140		1.126	-118			
D	0.210	0.230		1,221	.220			
Е	1.245	1.255		1250	1250	-		
F	1.245	1.255		1-250	11-250	·		† ·
G	2.495	2.505		2.500	0.500			
Н	0.510	0.515		.5/7	.5/2			
	1.572	1.582		1574	154			
J	2.495	2.505		2.500	2.500			 - ···
K	0.257	0.262		256	258		 -	
L	0.312	0.317		1.314	24	_		
M	0.235	0.240		.238	.238			- -
N _	0.100	0.140	<u> </u>	103	118		_	
0	0.540	0.560		549	.546			
P	0.490	0.510		-498	.499			
Q	3.715	3.725		3-120	3-100			
Ŕ	2.470	2.510	-	2.490	7 160			
S	0.240	0.270		248	250			
Т	0.100	0.180		135	135			
U	1.625	1.635		1636	7.630			
V	1.362	1.372		13/4	1314			
W	0.316	0.321	-	23/6	36			<u> </u>
\overline{x}	1.125	1.145		T 1738	1.138			
Y	1.565	1.585		548	1.578			<u> </u>
Z	0.178	0.198		188	188		- , ,	
AA				-100				
AB		 			† 			
AC		 	-		 			
AD		 			 			
AE		1 "						
			ccept/Reject					
	Measured		1.3.	08-21		Date:	3-8-18	
	Audited		44			Date:	13/08/2	. 2
	type Appro			V/A		Date:	N	I/A
Rev	Date	Change				Re	vised by	Approved
_A		New Issue				RF		1
В	02.12.12	DT8695 A/B	lded Dim. X-Y,		8686, DT8690	1 & KJ/	RF	
С	06.10.03	Removed DT8	3683, DT8686 8	R DT8690		K.I/	JLM	
D	07.03.21	Revised per d	rawing revision	С			JLM	
_ E _	08.01.16	DT8695 A/B re	emoved from di	mension Y			EC/DD	13/

	•	
		•
		t -
		• •
•		



*# B

ENGINE STAFF

UNCONTROLL DICEPTY

SUBJECT TO AMENDMENT

WITHOUTEN

WORK OND MC5 NO. 103664 MC5

.

: ¥